

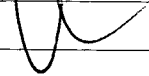
# Work Order ID 122232

**\*122232\***

July-14-14 11:38:45 AM

Page 1

Item ID: D3914-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Long Basket Lid Assembly (350)  
 Start Date: 7/14/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 7/18/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	C								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: **B123823** 0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

\*\*\*Visual inspect before welding mesh\*\*\*

3- tack weld mesh on basket as per dwg D3914

\*\*\*Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

**1x CC 14-7-15**

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Quality Control

Memo

0.00

**① 14-07-16** **DAS**  
**9**  
**9-89**

## Page 2

140	Wing Walk as per dwg QSI005 4.4 Batch <u>M12560307</u>	
<b>*140*</b>		
HandFinish	<b>Memo</b>	0.00
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg	
	2- Install label as per dwg	
	***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	

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Page 3

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>w10</u>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

MF  
14-7-22

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**\*122232\***

**\*D3914-041\***

**Required Date:** 7/18/14

**Required Qty: 1.00**

**Comments:** IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B  
as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS  
PER DWG REV.pcl DD VERF:JLM IPP REV:D 13.06.21 DWG  
REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3914-1		Manufactured	No			100	Each	4.0000	2	2			
<b>*D3914-1*</b>									<b>**</b>			CC 14-7-15	
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				4					
				115574				2					
				115575				2					
D3914-7		Manufactured	No			100	Each	11.0000	2	2			
<b>*D3914-7*</b>									<b>**</b>			CC 14-7-15	
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				11					
				115743				8					
				115744				2					
				115745				1					
D4018-5		Manufactured	No			100	Each	24.0000	9	9			
<b>*D4018-5*</b>									<b>**</b>			CC 14-7-15	
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				24					
				106726				3					
				110936				12					
				115947				9					

# Picklist Print

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Page 2

Work Order ID: 122232

**\*122232\***

Parent Item: D3914-041

**\*D3914-041\***

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/14/14

Required Date: 7/18/14

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100

Each

8.0000

2

2

**\*D4035-043\***

Lid Rib Assembly, Aft (350 Basket)

**\*\***

*CC 14-7-15*

Location

Loc Qty

Loc Code

WA004

8

114988

2

115935

2

119404

4

*(2x)*

D2581

Manufactured No

100

Each

168.0000

2

2

**\*D2581\***

Mounting Bracket

**\*\***

*CC 14-7-15*

Location

Loc Qty

Loc Code

WA

86

117900

86

WA004

82

102265

82

*(2x)*

D2728-3

Manufactured Yes

140

Each

0.0000

0

0

**\*D2728-3\***

Dart Logo Label Large

**\*\***

*all 11/6/15  
CC 14-7-15*

D4016-3

Manufactured No

100

Each

53.0000

3

3

**\*D4016-3\***

Hinge Half, Lid

**\*\***

*CC 14-7-15*

Location

Loc Qty

Loc Code

WA004

53

115144

4

117504

37

120493

4

121645

4

121855

4

*(3x)*

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Shop Packet Print

Page 2

# Picklist Print

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Page 3

Work Order ID: 122232

**\*122232\***

Parent Item: D3914-041

**\*D3914-041\***

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/14/14

Required Date: 7/18/14

Start Qty: 1.00

Required Qty: 1.00

D4020-5

Manufactured No

100

Each

3.0000

1

1

**\*D4020-5\***

Mesh (350 Basket Long, Lid)

**\*\***

*CC 14-7-15*

Location

Loc Qty

Loc Code

WA004

106804

3

3

100

Each

7.0000

1

1

D4021-3

Manufactured No

**\*D4021-3\***

Data Plate

**\*\***

*CC 14-7-15*

Location

Loc Qty

Loc Code

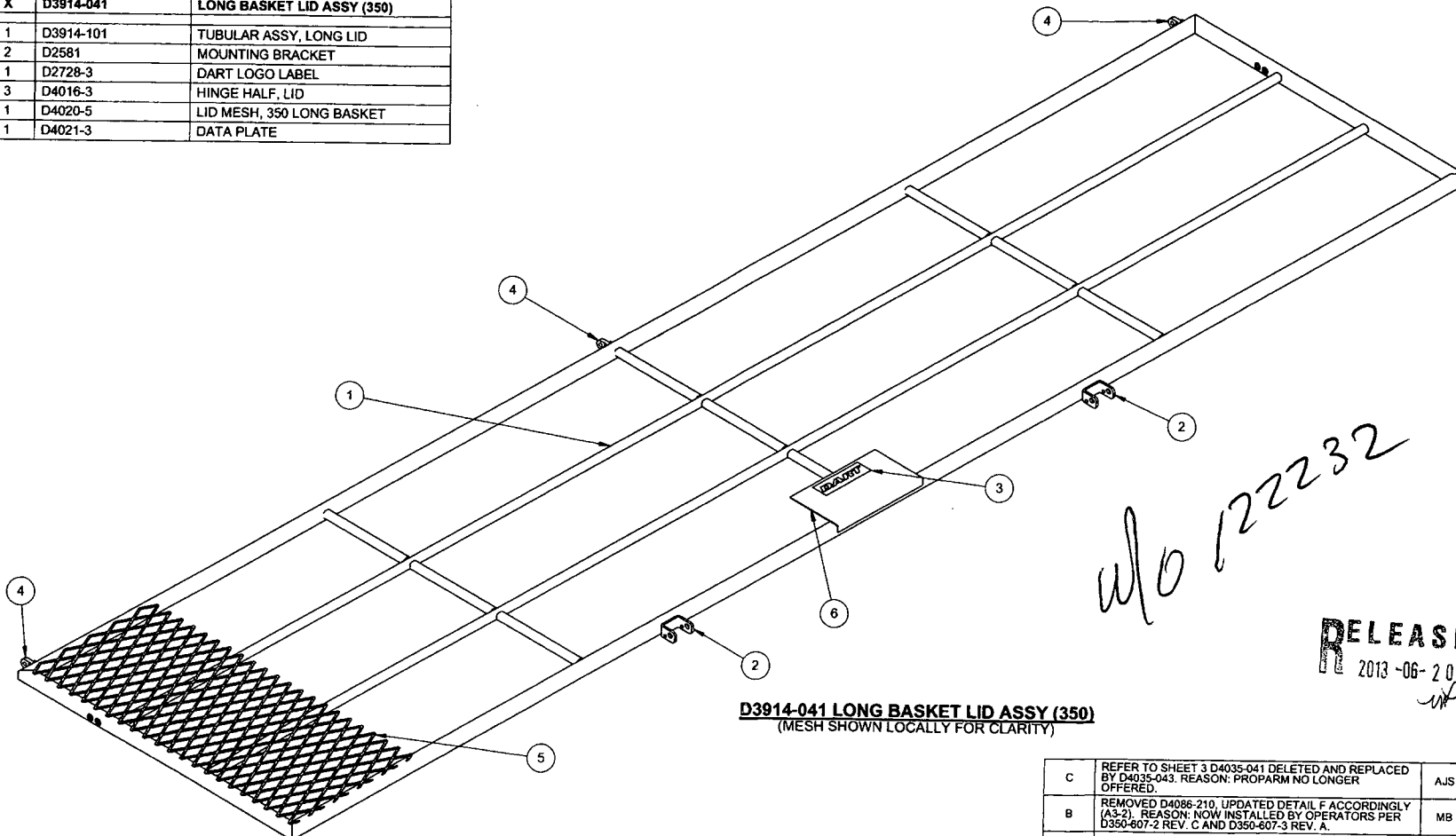
WA004

116081

7

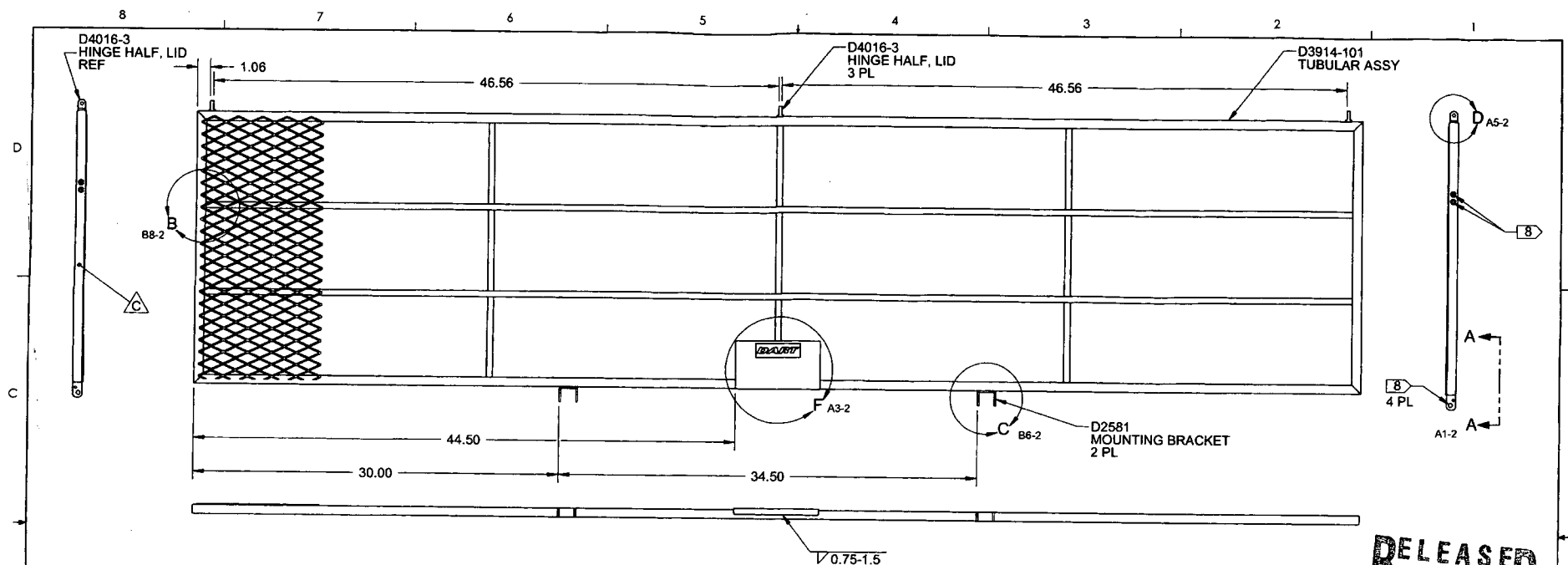
7

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
5	1	D4020-5	LID MESH, 350 LONG BASKET
6	1	D4021-3	DATA PLATE

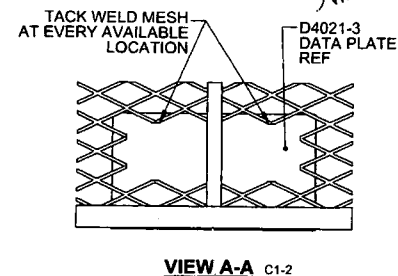
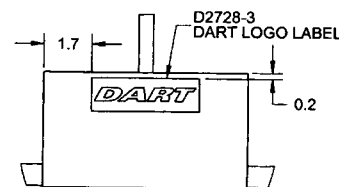
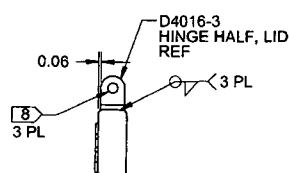
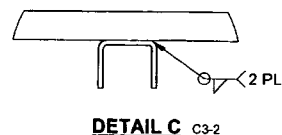
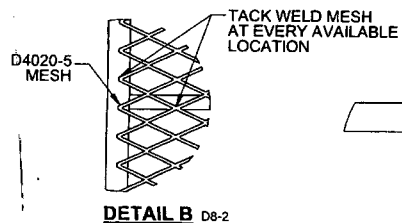


**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROPARM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	DS	D3914	SHEET 1 OF 4
APPROVED	12	TITLE	SCALE
DE APPR.	14	LONG BASKET LID ASSY (350)	NTS
DATE	13.03.13	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

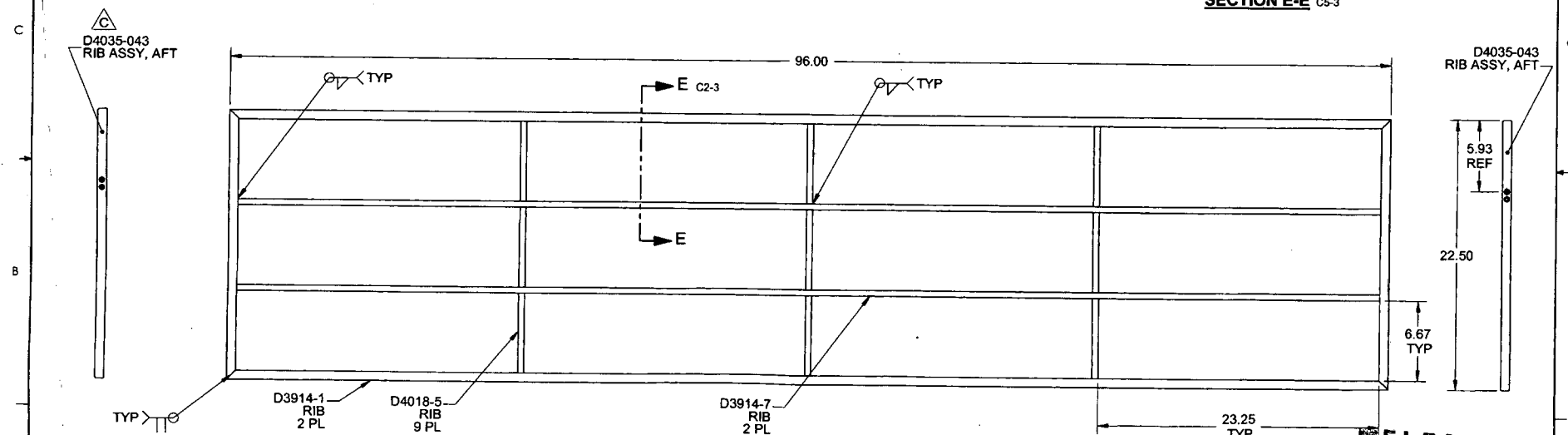
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	DS	D3914	SHEET 2 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	140	LONG BASKET LID ASSY (350)	NTS
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3

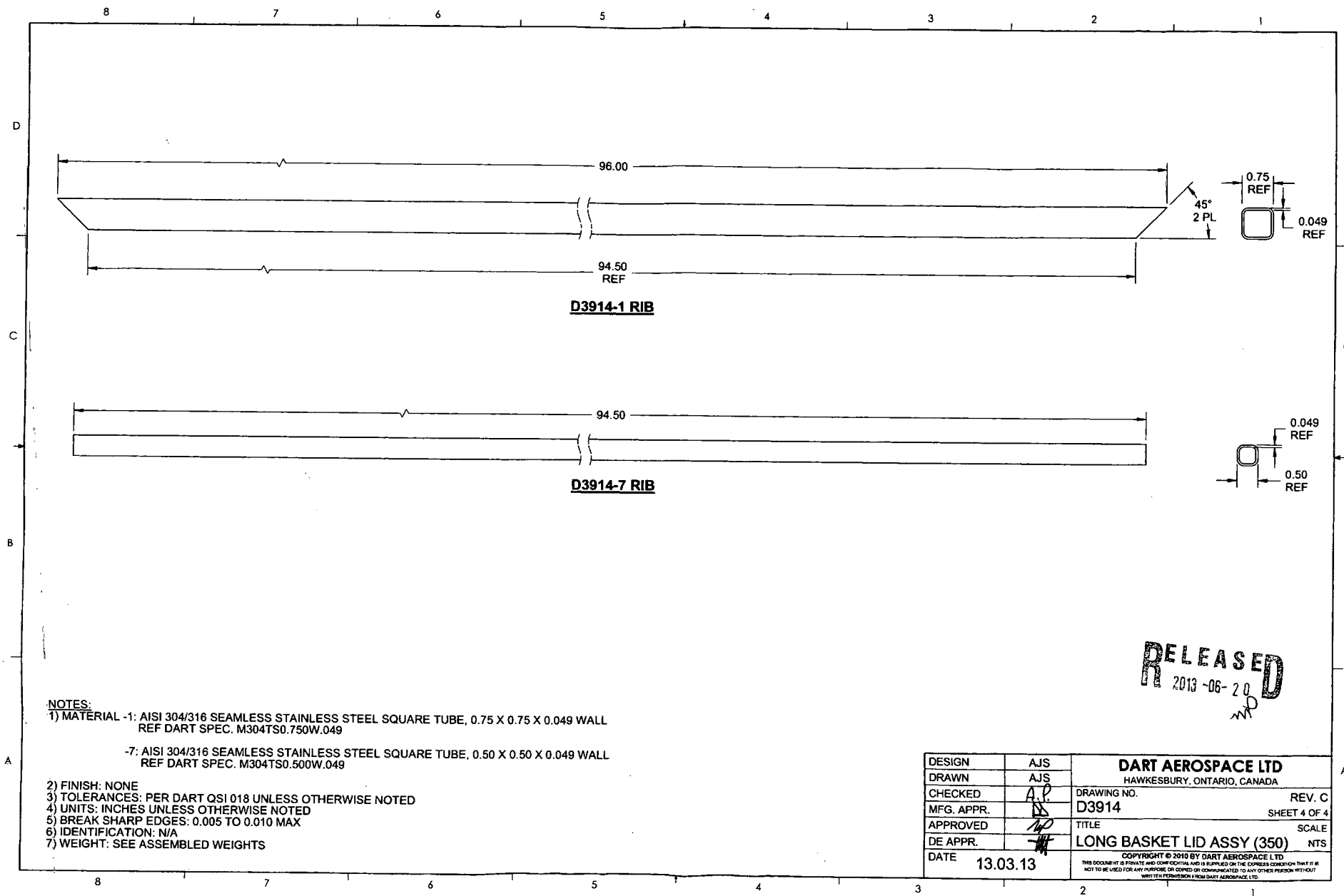


8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3914-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO. D3914	REV. C
MFG. APPR.	AJS	SHEET 3 OF 4	
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	LONG BASKET LID ASSY (350)	NTS
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**RELEASED**  
2013-06-20

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	NS	D3914	SHEET 4 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	140	LONG BASKET LID ASSY (350)	NTS
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